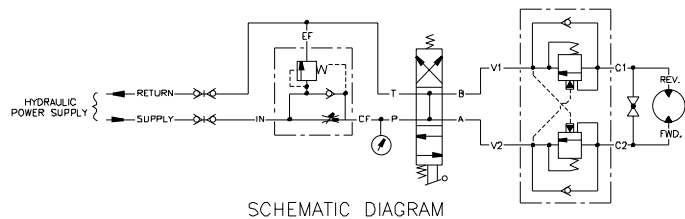


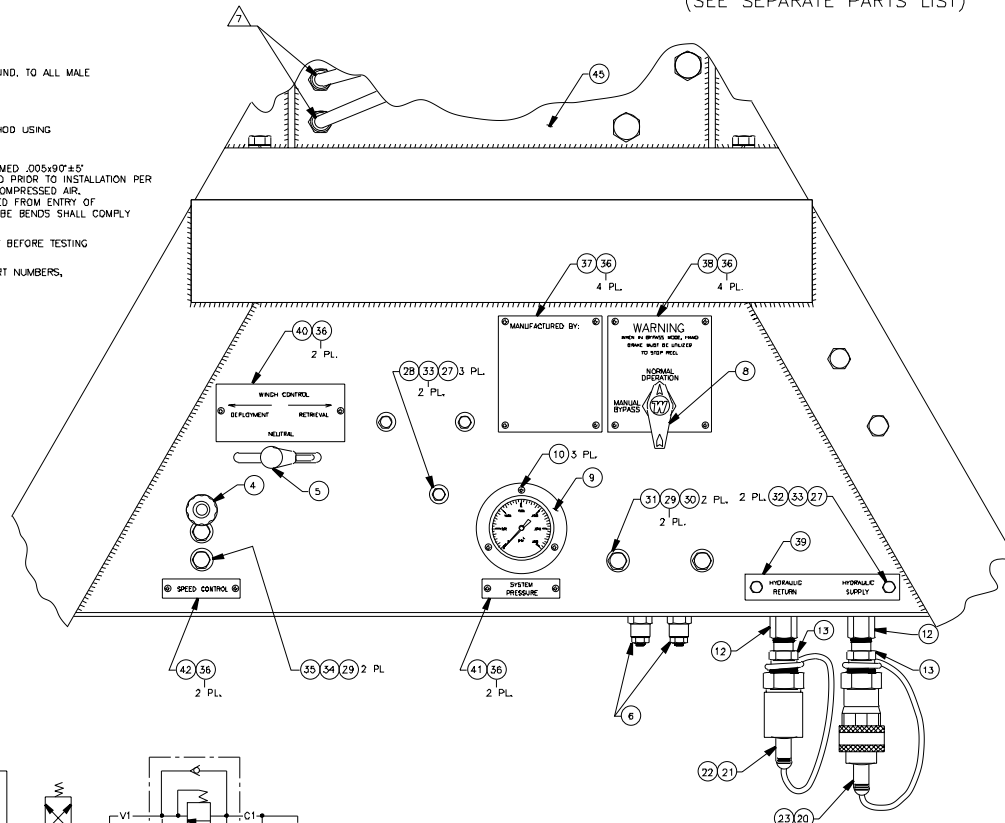
NOTES:

1. INTERPRET DRAWING PER MIL-STD-100E.
2. UNLESS OTHERWISE SPECIFIED:
 - A. BREAK ALL SHARP EDGES: .005-.016R. TYP.
 - B. FILLET RADIUS: .01-.02R. TYP.
 - C. SURFACE FINISH: 125
 - D. ALL FLAME OR SAW CUT SURFACES SHALL BE GROUND SMOOTH.
 - E. APPLY THIN UNIFORM COAT OF ITEM 24, THREAD SEALANT COMPOUND, TO ALL MALE PIPE THREADS. PTFE TEFLON TAPE MAY BE SUBSTITUTED.
3. ALL TUBING COMPONENTS SHALL BE PRE-SWAGED USING SWAGelok MS-ST-810 AND MS-ST-600, TOOLS AS APPLICABLE.
4. ALL SWAGED CONNECTIONS SHALL BE INSPECTION GAGED BY GAP METHOD USING SWAGelok MS-IG-810 AND MS-IG-600, AS APPLICABLE.
5. TUBING SHALL BE SEAMLESS CRES, FULLY ANNEALED, SUITABLE FOR BENDING, PER ASTM A269, TYPE 304. EACH END SHALL BE REAMED .005x90°±5' PRIOR TO SWAGED ASSEMBLY. TUBING ASSEMBLIES SHALL BE CLEANED PRIOR TO INSTALLATION PER MIL-STD-4190 AND DRIED WITH CLEAN, FILTERED, AND DEHYDRATED COMPRESSED AIR. PRE-FABRICATED TUBING ASSEMBLIES SHALL BE ADEQUATELY PROTECTED FROM ENTRY OF FOREIGN MATERIAL, DUST, DIRT, WATER, OR OTHER CONTAMINANTS. TUBE BENDS SHALL COMPLY WITH MINIMUM BEND RADI PER MS33611.
6. REMOVE VENT PLUG AND DISCARD GASKET FROM BLOW-OUT ASSEMBLY BEFORE TESTING AND/OR OPERATION
7. REFERENCE DWG. 172341 FOR ADDITIONAL ASSEMBLY DETAILS AND PART NUMBERS, INCLUDING MOTOR AND REDUCTION GEAR.



REV.	DATE	APPD.	DESCRIPTION	BY
1	03/94			

(SEE SEPARATE PARTS LIST)



REV.	DATE	APPD.	DESCRIPTION	BY
1	03/94			

CONTRACT NUMBER DTCC23-92-C-EC1069

UNLESS OTHERWISE SPECIFIED:
 ALL DIMENSIONS ARE IN INCHES.
 TOLERANCES: FRACTIONS DECIMALS ANGLES
 ±1/32 ±.01 ±1°
 ±.005 ±.005

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CONSULTANTS

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 CIVIL ENGINEERING
 WASHINGTON, DC



USCG, COMDT G-SEC-2
 2100 2ND STREET SW
 WASHINGTON, DC 20593-0001

ISSUE

01 07/17/81 LV
 MARK DATE DESCRIPTION

A/E PROJECT NO: 254

CAD FILE NAME: 21021510001

DESIGNED BY: RMS

DRAWN BY: JO

EDITED BY: RMS

CHECKED BY: RMS

SCALE: HALF PLOT SCALE:

SHEET TITLE

G-SEC-2C
 WASHINGTON DC

HYDRAULIC SYSTEM ASSY.

REVIEWED BY: REVIEWED BY: REVIEWED BY:

PROJECT ENG. BRANCH CHIEF G-ECV-30

CHEF, CIVIL ENG DATE

PROJECT NUMBER DRAWING NUMBER

172319

DISCIPLINE/SHT NO

98- SHEET 1 OF 3